

Work Order ID 77426

Tuesday, December 06, 2011 2:20:49 PM

77426

Page 1

Item ID: D3684-045 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: LEG ASSEMBLY
 Start Date: 12/6/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/9/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MF Date: 11-12-06 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3684	Rev D

100	Pick Kit	0.00
100		
Packaging	Memo	0.00
Packaging		

110	Small Fab	0.00
110		
Small Fab	Memo	0.00
Small Fab		

1-Use anti-seize compound Tectly 502c Class 1, Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3684

2-Assemble D3693-1 & D3691-1 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3684

ensure holes AN3C bolts are clear of sealant

Torque Fastners as per Dwg D3684

Signature 11/12/08 ①

Signature 11/12/08 ②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		8/11/12/08		(X)			
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00		SNIP					
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

mf
11-12-08

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Picklist Print

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Work Order ID: 77426
Parent Item: D3684-045
Parent Item Name: LEG ASSEMBLY

Start Date: 12/6/2011
Start Qty: 1.00
Required Date: 12/9/2011
Required Qty: 1.00

Comments: IPP Rev:A new issue 08-02-12 DD verified by:JLM
IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC
03-16 JLM VERIFIED BY:EC
IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD
IPP REV:C AS PER REV D 10-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN3C12A
Bolts

Purchased No

110 Each 90.0000

2 2

Location	Loc Qty	Loc Code
ST351	90	
117514	4	
118112	5	
118422	17	
118451	22	
119510	42	

D3688-5
STUD

Manufactured No

110 Each 4.0000

1 1

Location	Loc Qty	Loc Code
GA	4	
46054	1	
72042	3	

D3689-1
SLEEVE

Manufactured No

110 Each 11.0000

1 1

Location	Loc Qty	Loc Code
GA	4	
70858	4	
ST075	7	
72117	7	

D3691-1
STUD

Manufactured No

110 Each 10.0000

1 1

Location	Loc Qty	Loc Code
GA	10	
62181	10	

EP 11/12/08
M118412
(2x)

EP 11/12/08

EP 11/12/08

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D3684-045

Parent Item Name: LEG ASSEMBLY

Start Date: 12/6/2011

Required Date: 12/9/2011

Start Qty: 1.00

Required Qty: 1.00

D3692-1
SPACER

Manufactured No

110 Each 141.0000

4 4

EP 11/12/08

Location

Loc Qty

Loc Code

ST075

141

51467

41

73232

100

4

D3693-1
Rod End Bearing

Manufactured No

110 Each 8.0000

1 1

EP 11/12/08

Location

Loc Qty

Loc Code

GA

8

50734

8

1

MS21043-3
Nut

Purchased No

110 Each 856.0000

2 2

EP 11/12/08

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

784

118077

1

118614

449

118686

104

119758

230

2

NAS509-12C
Nuts

Purchased No

110 Each 14.0000

1 1

EP 11/12/08

Location

Loc Qty

Loc Code

ST280

14

112453

14

1

NAS509L12C
Nuts

Purchased No

110 Each 19.0000

1 1

EP 11/12/08

Location

Loc Qty

Loc Code

ST279

19

112314

9

112828

10

1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

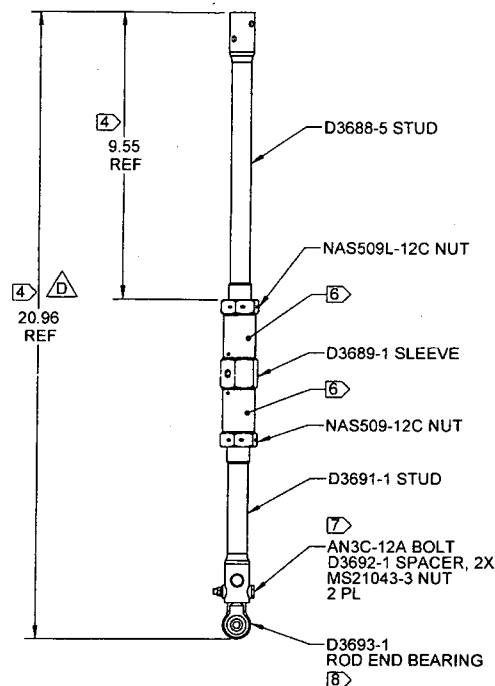
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ITEM	QTY -045	PART NUMBER	DESCRIPTION
1	X	D3684-045	INBOARD LEG ASSEMBLY
2	1	D3688-5	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT







D3684-045 INBOARD LEG ASSEMBLY

RELEASED
2010-03-15

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3684-045 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSION SHOWN IS WHEN D3688-5 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.1 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3684	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TRIPOD MOUNT ASSY	NTS
DATE	10.03.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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